

Work Order ID 108493

October-17-13 1:35:54 PM

108493

Page 1

Item ID: 646.4002 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AS350 Wiper Deflector
 Start Date: 10/17/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/17/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 13-10-21 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.4000	A								
100	DOCUMENT CONTROL	0.00	DAS						
100			27						
DC	Memo	0.00	9-89						
Document Control	Photocopy bluefile & type labels per PPP 646.4002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00	DAS						
120			27						
QC	Memo	0.00	9-89						
Quality Control									

1 *[Signature]* MLJ 13-11-13

1 *[Signature]* DAS 33 9-89 13-11-13

1 *[Signature]*

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 108493

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Item ID: 646.4002

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: AS350 Wiper Deflector

Stop *NS2*

Start Date: 10/17/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 10/17/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				1	8	13-11-20	
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP 646.4002								
	Location 66093								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

13/11/21

MF 13-11-28

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
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<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 1

Work Order ID: 108493

Parent Item: 646.4002

Parent Item Name: AS350 Wiper Deflector

Start Date: 10/17/13

Required Date: 10/17/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.12.23 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.3410 LH Wiper Deflector		Manufactured	No				Each	39.0000		0		DAS 33 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST139A		15							DAS 33 9-89
				125083		15							
				ST537		24				97822			
				97822		24							
646.3411 RH Wiper Deflector		Manufactured	No				Each	38.0000		0		DAS 33 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST139A		16							DAS 33 9-89
				125083		16				125083			
				ST523		22							
				97823		22							
NAS1149F0332P Washer		Purchased	No				Each	8,102.0000		16		DAS 33 9-89	13-11-13
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		182							DAS 33 9-89
				122063		182							
				ST294		158							
				122063		158							
				ST295		3							
				123352		3							
				st510		2759							
				123900		2759							
				ST510a		5000				123900			
				125646		5000							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

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Work Order ID: 108493
 Parent Item: 646.4002
 Parent Item Name: AS350 Wiper Deflector

Start Date: 10/17/13

Required Date: 10/17/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

Each

4,837.0000

6

DAS

33

9-89

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001	3	
122141	3	
GA	18	
122452	18	
ST314	304	
111668	1	
117885	32	
119017	55	
119075	138	
123265	43	
M126036	35	
ST506	1055	
123900	849	
124291	206	
ST510a	3457	
M126275	5	
M126333	3452	

126333

MS27039-1-19

Purchased

No

Each

1,204.0000

2

DAS

33

9-89

Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

ST306	102	
122814	2	
123522	100	
ST504	1000	
125654	1000	
ST506	102	
124326	102	

124326

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Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div>
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

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Work Order ID: 108493
 Parent Item: 646.4002
 Parent Item Name: AS350 Wiper Deflector

Start Date: 10/17/13

Required Date: 10/17/13

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-18

Screw

DAS
27
9-89

Purchased No

Each 1,977.0000



DAS
33
9-89

Location

Loc Qty

Loc Code

ST516

1977

124326

1977

124326
2

DAS
31
9-89

646.3814

Wiper Bracket

DAS
27
9-89

Manufactured No

Each 45.0000

Location

Loc Qty

Loc Code

ST139A

45

125083

45

125083

DAS
33
9-89

DAS
31
9-89

600.1012

Sealant (#654 semkit)

Purchased No

Each 99.0000



DAS
33
9-89

Location

Loc Qty

Loc Code

ST

70

m127099

70

ST519

29

m126248

18

m126972

11

126248

DAS
31
9-89

DAS
27
9-89

MS24694-S53

SCREW

Purchased No

Each 315.0000



DAS
33
9-89

Location

Loc Qty

Loc Code

ST303

315

113288

15

113359

300

113288

DAS
31
9-89

DAS
27
9-89

NAS1149F0363P

WASHER

DAS
27
9-89

Purchased No

Each 870.0000



DAS
33
9-89

Location

Loc Qty

Loc Code

ST295

870

122815

70

124555

600

125445

200

122815

DAS
31
9-89

13-11-13

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Shop Packet Print

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03079

SHEET 1 OF 1

DWG NO. 646.4000

REV: A

PREPARED BY: N.CAP

DATE: 03/21/11

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: AS350 CABLE CUTTERS KIT

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: CREATED FIXED AND CCK WITHOUT FIXED PROVISIONS KIT

SHEET 1, BOM, IS:

108493 MLJ
13-10-21

REF	REF	REF	65	647.5701	GPS MOUNT KIT	
			64	601.3151	WASHER	MS247000P
			63	601.2911	SCREW	MS24694533
			62	601.2637	SCREW	MS27809-1-16
			61	601.2763	BOLT	MS247000P
			60	646.3913	SHIM	
			59	646.3912	SHIM	
			58	646.3911	SHIM	
			57	646.3910	SHIM	
			56	600.1013	PRIMER	
			55	600.0129	VHB TAPE	
			54	600.1012	SEALANT	PR-1425 CLASS 3
REF	REF	REF	65	PART #	DESCRIPTION	MATL
AS350	AS350	AS350	AS350	AS350	AS350	SPEC.

1	1	53	600.0991	PACKAGING 6398 PART B		
1	1	52	600.0990	PACKAGING 6398 PART A		
1	1	51	601.2826	BOLT	MS247000P	
2	2	50	646.3814	VIPER BRACKET		
2	2	49	601.2910	SCREW	MS27809-1-18	
2	2	48	601.3655	SCREW	MS27809-1-18	
2	2	47	646.3719	DOUBLER		
2	2	46	646.3718	CUSTOM WASHER		
1	1	45	646.3717	DOUBLER		
22	22	44	601.1948	SCREW	MS27809-1-19	
2	2	43	601.1952	SCREW	MS27809-1-19	
4	4	42	601.1956	SCREW	MS27809-1-21	
2	2	41	601.2829	SCREW	MS24694534	
2	2	40	601.2831	RIVET	MS247000P-7	
1	1	39	646.3716	GAUGE BRACKET		
6	6	38	601.1953	SCREW	MS27809-1-12	
2	2	37	646.3715	STRUT DOUBLER		
2	2	36	601.2824	BOLT	MS247000P	
36	36	35	601.2277	RIVET	MS247000P-3-02	
18	18	34	600.0795	NUTPLATE	MS247000P-3	
3	3	33	601.2565	RIVET	MS247000P-7	
1	1	32	646.3813	STRUT BRACKET		
4	4	31	601.2822	BOLT	MS247000P	
2	2	30	646.3812	GUSSET BRACKET		
8	8	29	601.2564	RIVET	MS247000P-6	
1	1	28	646.3714	GUSSET		
1	1	27	646.3610	FILLER		
1	1	26	601.2830	SCREW	MS24694533	
2	2	25	601.2825	BOLT	MS247000P	
1	1	24	646.3811	RADIUS BLOCK		
1	1	23	646.3712	CLIP		
1	1	22	646.3711	CLIP		
8	8	21	601.2832	RIVET	MS247000P-03	
14	14	20	601.2020	RIVET	MS247000P-5-3	
10	10	19	601.2823	BOLT	MS247000P	
1	1	18	601.2827	BOLT	MS247000P	
5	5	17	601.2912	SCREW	MS24694532	
1	1	16	646.3713	GUSSET		
1	1	15	646.3210	SUPPORT		
1	1	14	646.3710	DOUBLER		
1	1	13	646.3110	CHANNEL		
8	8	12	601.1624	LOCKNUT	MS247000P	
18	18	11	601.1607	WASHER	MS247000P	
1	1	10	646.3411	RH VIPER DEFLECTOR		
1	1	9	646.3410	LH VIPER DEFLECTOR		
1	1	8	646.3513	STRUT		
1	1	7	646.3512	STRUT		
1	1	6	646.3511	STRUT		
2	2	5	646.3510	STRUT		
2	2	4	646.3810	BRACKET		
1	1	3	646.2910	DEFLECTOR		
1	1	2	646.3001	LOWER CUTTER ASSY		
1	1	1	646.3301	UPPER CUTTER ASSY		
X	X		646.4004	FIXED PROVISIONS KIT		
X	X		646.4003	FIXED PROVISIONS KIT		
X	X		646.4002	FIXED PROVISIONS KIT		
X	X		646.4001	AS350 CABLE CUTTERS KIT		
REF	REF	REF	65	PART #	DESCRIPTION	MATL
AS350	AS350	AS350	AS350	AS350	AS350	SPEC.

DOCUMENTS EFFECTED:

☒ MDL ☒ INSTALL INSTRU ☒ ICA ☒ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

108493

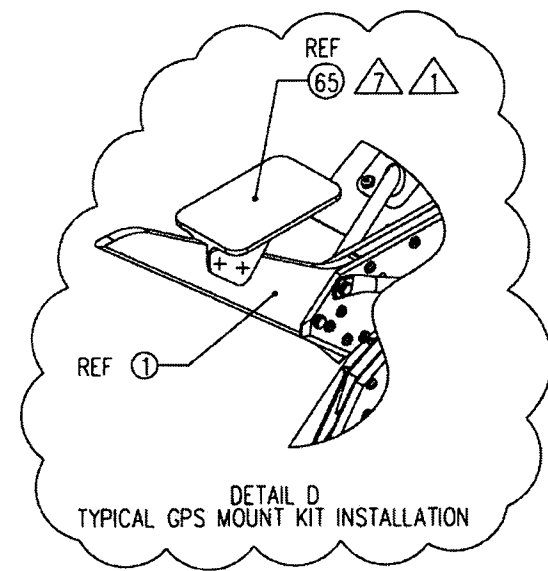
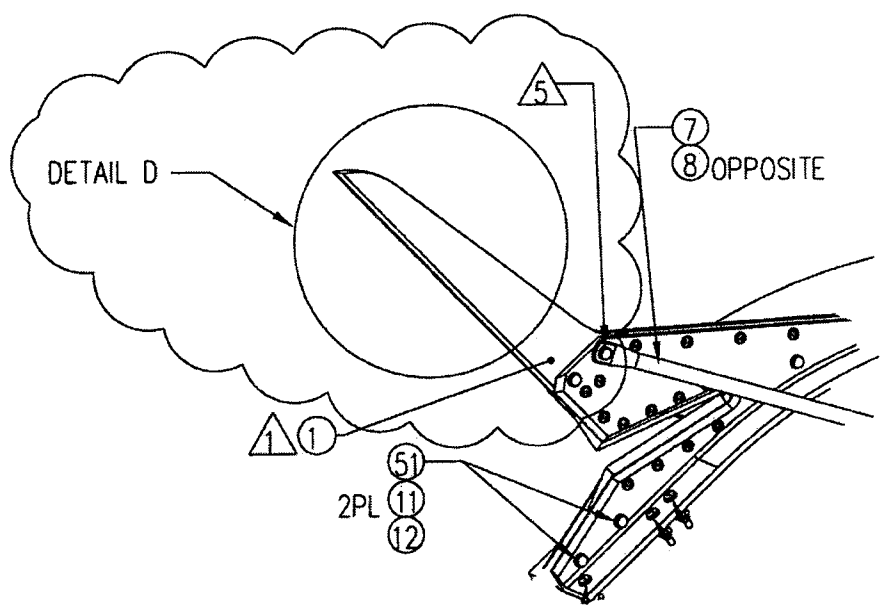
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03046				SHEET 1 OF 1	
	DWG NO. 646.4000	REV: A	PREPARED BY J. JACKSON	DATE: 01/24/11	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: AS350 CABLE CUTTERS KIT					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: ADDED GPS MOUNT KIT, F/N 65. REVISED DRAWING VIEWS. ADDED NOTE 7.				

SHEET 1, ZONE B1 IS:

7 AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ONTO F/N 1.

SHEET 2, ZONE A4 IS:

SHEET 2, ZONE B2 IS:



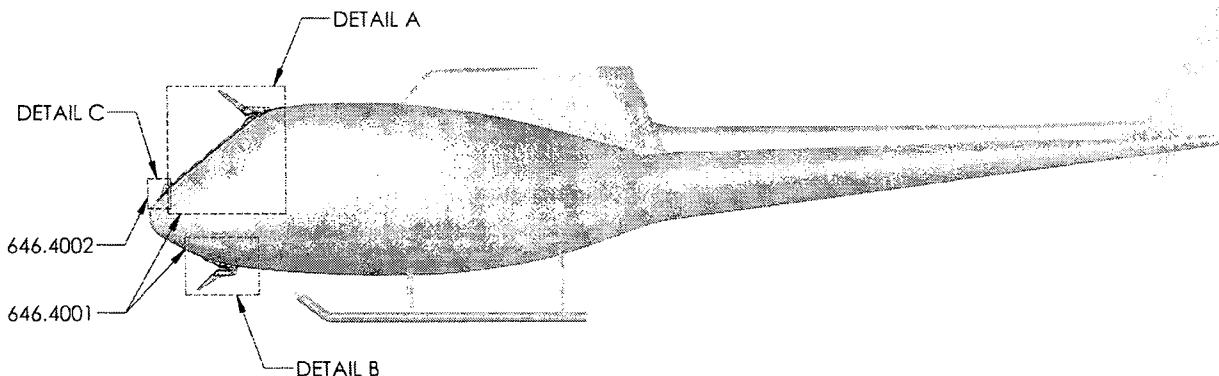
65	A	647.5701	REF	GPS MOUNT KIT	7	
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
			.4001			
DOCUMENTS EFFECTED:					CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	
<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input checked="" type="checkbox"/> BOM					DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	

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NOTES:

- 1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES
- 2 INSTALL F/N 14 WITH F/N 52 & 53
- 3 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651
- 4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE
VENDOR: R.S. HUGHES P/N 021200-24216
- 5 REUSE FASTENERS FROM F/N 1
- 6 USE WASHERS AS REQUIRED AS SHIMS TO OBTAIN BEST FITMENT



QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
6	64	601.3151	WASHER	MS21499-385P	
2	63	601.2911	SCREW	MS24694-553	
2	62	601.2637	SCREW	MS27039-1-16	
2	61	601.2763	BOLT	AN3-17A	
1	60	646.3913	SHIM		
4	59	646.3912	SHIM		
1	58	646.3911	SHIM		

UNLESS OTHERWISE SPECIFIED ECN(S)

03046, 03079

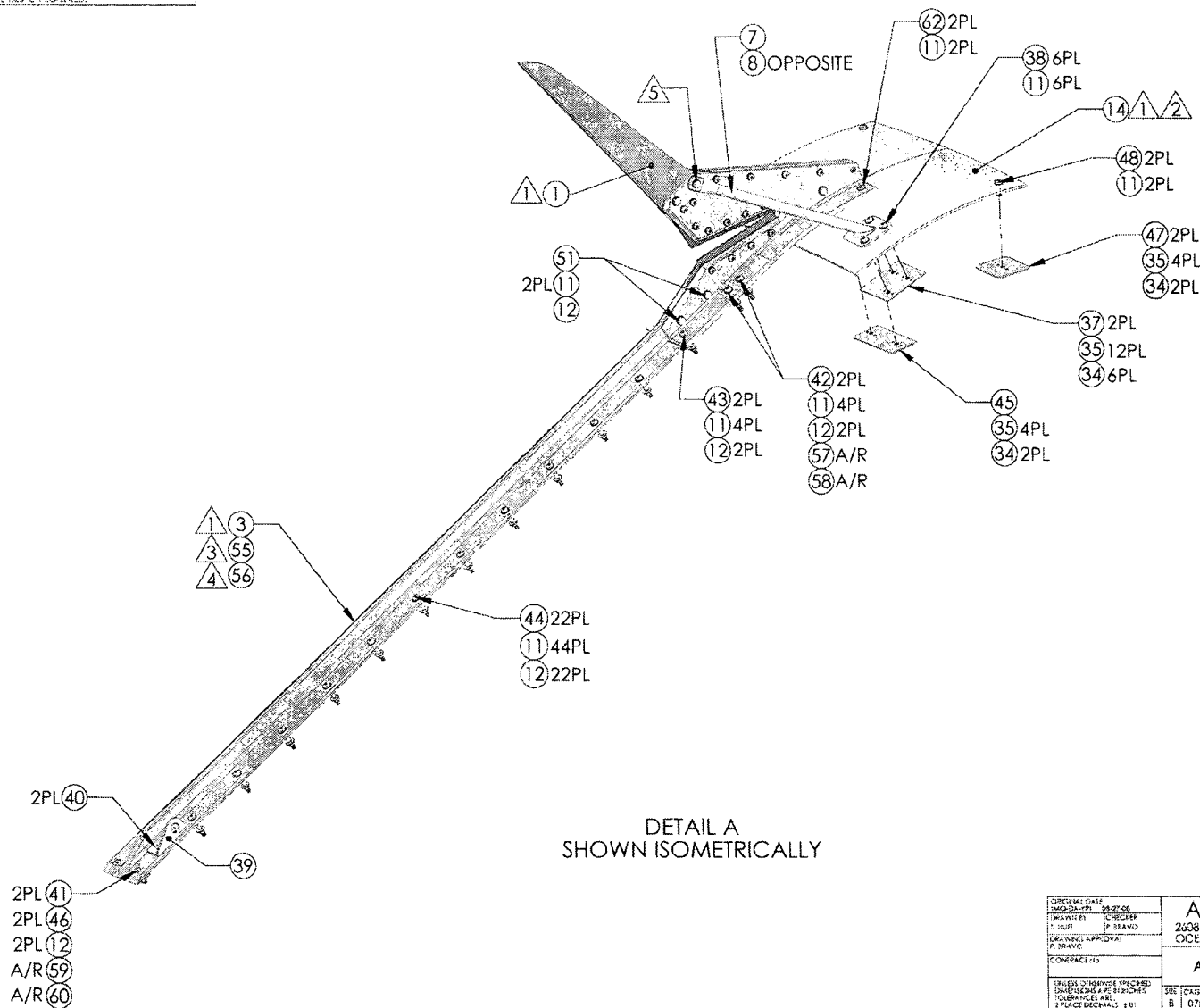
REV	DESCRIPTION	DATE	APPROVED
A	REWORKED FOR ECN(S) 03046, 03079, 03078	03/08/02	P. BRAVO

QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
4	57	646.3910	SHIM		
5	56	600.1013	PRIMER		
5	55	600.0129	VHB TAPE		
1	54	600.1012	SEALANT	PR-1451 CLASS D	
1	53	600.0991	MAGNABONCH 5078 PART B		
1	52	600.0990	MAGNABONCH 5078 PART A		
8	51	601.2826	BOLT	AN3-17A	
2	50	646.3814	WIPER BRACKET		
2	49	601.2910	SCREW	MS27039-1-16	
2	48	601.1365	SCREW	MS27039-1-10	
2	47	646.3719	DOUBLER		
2	46	646.3718	CUSTOM WASHER		
2	45	646.3717	DOUBLER		
2	44	601.1948	SCREW	MS27039-1-16	
2	43	601.1952	SCREW	MS27039-1-20	
4	42	601.1956	SCREW	MS27039-1-20	
2	41	601.2829	SCREW	MS27039-1-20	
2	40	601.2831	RIVET	MS27039-1-20	
1	39	646.3716	GAUGE BRACKET	MS27039-1-12	
6	38	601.1955	SCREW	MS27039-1-12	
2	37	646.3715	STRUT DOUBLER		
2	36	601.2824	BOLT	AN3-5A	
36	35	601.2277	RIVET	CUTTER-300	
18	34	600.0795	NUT PLATE	MS27047-3	
3	33	601.2565	RIVET	MS27047-3	
1	32	646.3813	STRUT BRACKET		
4	31	601.2822	BOLT	AN3-2A	
2	30	646.3812	GUSSET BRACKET		
8	29	601.2564	RIVET	MS27047-3	
1	28	646.3714	GUSSET		
1	27	646.3610	FILLER		
1	26	601.2830	SCREW	MS27047-3	
2	25	601.2825	BOLT	AN3-6A	
1	24	646.3811	RADIUS BLOCK		
1	23	646.3712	CLIP		
1	22	646.3711	CLIP		
8	21	601.2832	RIVET	MS27047-3	
14	20	601.2020	RIVET	CR2113-5-2	
10	19	601.2823	BOLT	AN3-6A	
1	18	601.2827	BOLT	AN3-13A	
5	17	601.2912	SCREW	MS27047-3	
1	16	646.3713	GUSSET		
1	15	646.3210	SUPPORT		
1	14	646.3710	DOUBLER		
1	13	646.3110	CHANNEL		
6	63	601.1624	LOCKNUT	MS27047-3	
16	134	601.1607	WASHER	MS27047-3	
1	10	646.3411	RH WIPER DEFLECTOR		
1	9	646.3410	LH WIPER DEFLECTOR		
1	8	646.3513	STRUT		
1	7	646.3512	STRUT		
1	6	646.3511	STRUT		
1	5	646.3510	STRUT		
2	4	646.3810	BRACKET		
1	3	646.2910	DEFLECTOR		
1	2	646.3001	LOWER CUTTER ASSY		
1	1	646.3001	UPPER CUTTER ASSY		
1	1	646.4002	AS350 WIPER DEFLECTOR KIT		
1	1	646.4001	AS350 CABLE CUTTERS KIT		

QTY	REVISION DATE: 08-27-08	PARTS LIST	
NEXT ASSY (S)	APPROVED BY: P. BRAVO	APICAL INDUSTRIES	
	DESIGNED BY: P. BRAVO	2608 TEMPLE HEIGHTS DR.	
	APPROVED BY: P. BRAVO	OCEANSIDE, CA 92056-3512 (760) 724-5300	
	DESIGNED BY: P. BRAVO	AS350 CABLE CUTTERS KIT	
	APPROVED BY: P. BRAVO		
	UNLESS OTHERWISE SPECIFIED	REV. A	
	ENGINEERING: P. BRAVO	SCALE: NONE	
	MANUFACTURING: P. BRAVO	SHEET 1 OF 4	
	INSPECTION: P. BRAVO		

108493

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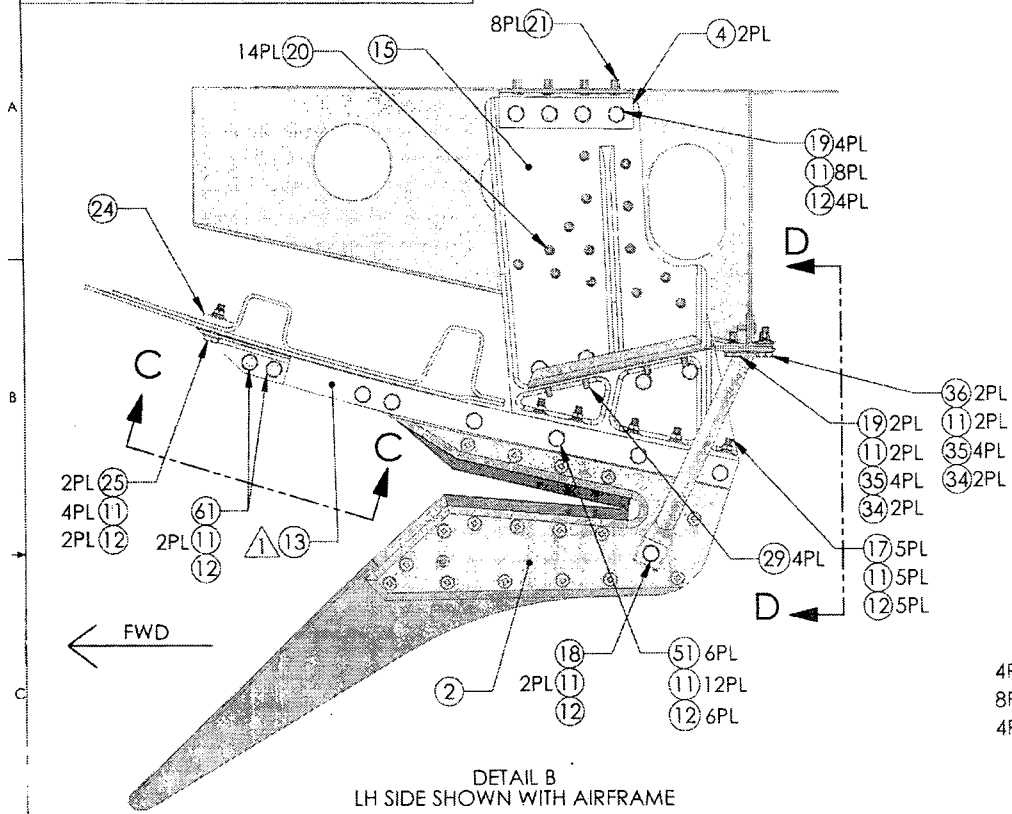
DETAIL A
SHOWN ISOMETRICALLY

ORIGINAL DATE 06/27/08 DRAWN BY P. BRADY CHECKED BY P. BRADY DRAWING APPROVAL P. BRADY CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 DECIMALS 3 INCHES DECIMALS 3 INCHES DECIMALS 3 INCHES DECIMALS		AS350 CABLE CUTTERS KIT	
SIZE B	QUANTITY 1	PRICE 646.4000	REV. A
SCALE: NONE		1 SHEET 2 OF 4	

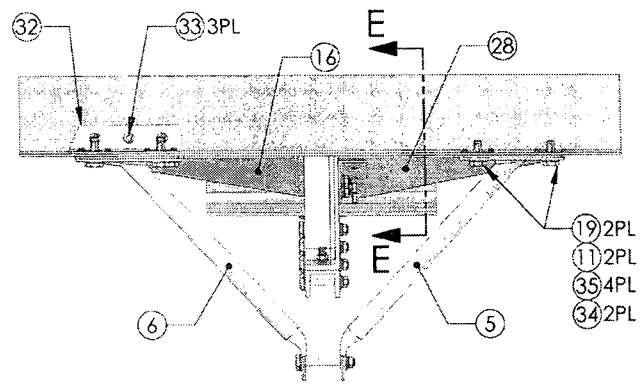
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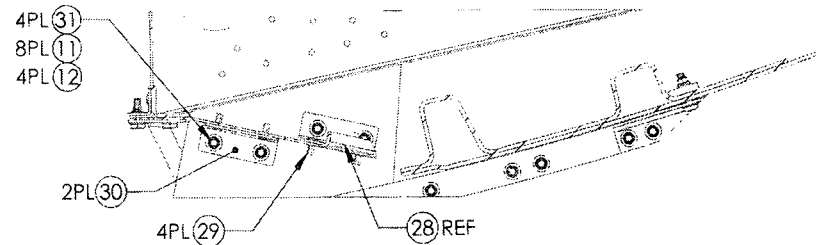
REVISIONS		DATE	APPROVED
REV	DESCRIPTION		



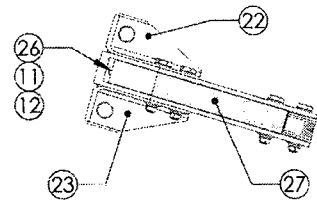
DETAIL B
LH SIDE SHOWN WITH AIRFRAME



SECTION D-D
CUTTER HIDDEN FOR CLARITY



SECTION E-E



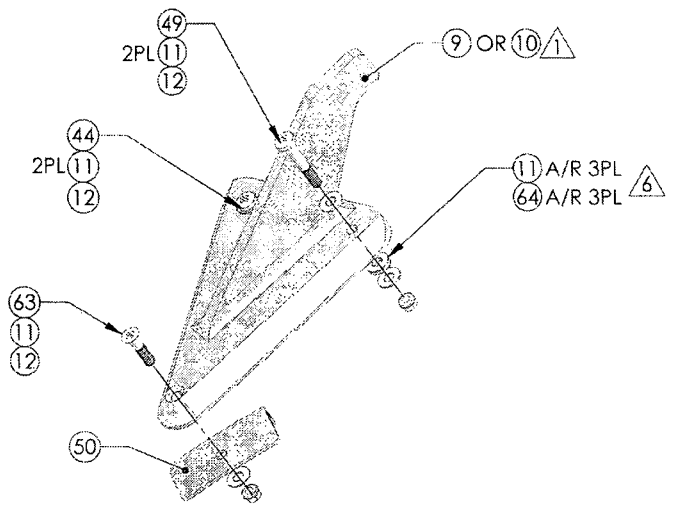
SECTION C-C

ORIGINAL DATE 08/22/08	REV: 08/22/08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
DRAWN BY: J. HILL CHECKED BY: P. BRAY DESIGNED BY: P. BRAY	DATE: 08/22/08				
DRAWING APPROVAL P. BRAY 08/22/08		AS350 CABLE CUTTERS KIT			
COPPERFILLING					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ±.01 2 FRACTIONS DECIMALS ±.01 ANGLES ±.5°		SIZE: 8	CAGE CODE: 07M16	DWG. NO.: 646.4000	REV. A
		SCALE: NONE		SHEET 3 OF 4	

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REV	DESCRIPTION	DATE	APPROVED



DETAIL C
LH SHOWN EXPLODED
RH OPPOSITE

FORM DATE: 08-27-08 END DATE: 08-27-08 DRAWN BY: CHUCKLE S. HEP P. BRAVO REWORK APPROVAL: P. BRAVO CHECKED: COMPARISON NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACES DECIMALS ±.01 3 PLACES DECIMALS ±.005 ANGLES ±.5°		REV: B CAGE CODE: 07M26 QNTG: 646.4000 SCALE: NONE	REV: A SHEET: 4 OF 4

